

Thursday, 8/23/2007 4:15:07 PM  
Kim Johnston

## Process Sheet

SB 07/09/24 Split

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 34260 -1  
Estimate Number : 12811  
P.O. Number : N/A  
This Issue : 8/23/2007 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : SMALL /MED FAB  
Previous Run : 32661  
Written By :  
Checked & Approved By :  
Comment : Est Rev.A New Issue 07-03.26 ec

Drawing Name : BRACKET  
Part Number : D35921  
Drawing Number : D3592 UNDER REVIEW  
Project Number : N/A  
Drawing Revision : REV B  
Material : N/A  
Due Date : 8/30/2007 Qty: 40 Um: Each

Additional Product:

Job Number:



Seq. #: Machine Or Operation: Description:

10 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty: 0.1460 sf(s)/Unit Total: 5.8380 sf(s)

6061-T6 .125 Sheet

Batch: M102272 IB07-08-24

Scrap 22

\*\*\*Grain must be Along 4.63\*\*\*\*\*

M102272 33

M101092 2

40 total

SAD 07/08/25

20 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3592

Dwg Rev: B

Prog Rev: B

IB07-08-24

2-Deburr if necessary

SAD 07/08/25

40

30 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 07-08-24



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/25

40

40 QC8 SECOND CHECK



Comment: SECOND CHECK

En 11/09/25

X40

center

50 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

PTO

Form as per Dwg D3592 using DT8949

SB 07/09/24 20

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/09/26	5	Splice w/o	SB	07/09/26	(20)		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 07/09/28

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 34260

Part Number: D35921

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*counts*  
*En 07/09/26 (420)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*1/9/26 50*

*(25x)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(20)*  
*207/09/28*

Job Completion:



*u 07-09-28*





Description: BRACKET

Part Number:	D32921
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specimen Dwg: D3542 Rev: B

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### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

## Prototype

Measured by:	SAB
Date:	07/08/25

Audited by:	CS
Date:	07/08/20

Prototype Approval:	<i>MA</i>
Date:	



**Chris Provencal**

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**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** June 7, 2007 3:37 PM  
**To:** 'Chris Provencal'  
**Subject:** RE: D3562-041/-042

As we discussed, I think this change is acceptable without further qualification.

David

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**From:** Chris Provencal [mailto:cprovencal@dartaero.com]  
**Sent:** Thursday, June 07, 2007 1:15 PM  
**To:** David Shepherd (David Shepherd)  
**Subject:** D3562-041/-042

David,

For the D3562-041/-042 Step Assembly, we need to remove qty(1) rivet from each D3560-XX Arm weldments attachments for manufacturability. There will be a total qty(34) MS20600AD4 rivets instead of qty(36) per step. The rivet will be removed from the side surface of the step. Remaining shear would be 350 lbs x 16 rivets = 5600 lbs per arm attachments.

-Chris

No virus found in this incoming message.

Checked by AVG Free Edition.

Version: 7.5.472 / Virus Database: 269.8.11/838 - Release Date: 6/7/2007 2:21 PM

No virus found in this outgoing message.

Checked by AVG Free Edition.

Version: 7.5.472 / Virus Database: 269.8.11/838 - Release Date: 6/7/2007 2:21 PM

27/08/2007





Preventive Action Report						PAR 196	
Raised by: MARC BELLAVANCE			Source: ENG / G.A.			Sheet No. 1 of 1	
Issue for Dept./Supplier: ENGINEERING						Date: 07.09.25	
Product/Service: D3562-041/-042 STEP ASSEMBLY						Priority: HIGH LOW	
<b>Area of Standard:</b>		<b>Section A Description of Issue</b>					
QSI		<p>GRIND DIRECTION IS WRONG SHOULD BE CORRECTED TO 45° TO HELP WELDING PENETRATION.</p> <p><i>Forward to Director, Quality Assurance on completion of this box</i></p>					
QSP							
QSPM							
<b>Documents:</b>							
P/O							
Invoice							
W/O LBN							
Batch No. 24240							
TSR							
Drawing D3562-1							
DQA Section B: Indicate who is responsible for creating P/A, and a completion date, Section C: Indicate who will verify completion of P/A.							
<b>Section B Preventive Action</b>		Responsible for Investigation/PA: M. BELLAVERE To be done by: 07.10.25					
No	Initial	Action Description	Responsible	Due date	Sign/Date		
I	M.B.	RUN BATCH THROUGH GRINDING MACHINE AT AN ANGLE OF 45°	JLI	1. SEP			
						<b>Fault Category:</b>	
<b>Section C Verification of P/A</b>		Responsible for Verification of PA:					
No	Verification Method		Sign	Date			
					Forward to DQA on Completion of Verification		
					DQA: _____		
					Date: _____		
QA Purposes only			P/A Closed	Date			

